

Date

Monday, 2/5/2007 10:45:31 AM

User:

Process Sheet

Customer Job Number

: CU-DAR001 Dart Helicopters Services

: 30635

Estimate Number

Previous Run

Written By

P.O. Number

: HA : 2/5/2007

S.O. No. : NA

This Issue Prsht Rev. First Issue

: MACHINED PARTS

: 30206

Checked & Approved By Comment

: Est Rev:A New Issue 06-10.03 EC **Drawing Name**

: HINGE BRACKET

Part Number **Drawing Number** : D35381 D3538 REV.A

Project Number **Drawing Revision** · 10254N/A

Material Due Date

: 2/12/2007

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

6061-T6 Bar 1.25 x 1.25"

1.0

Comment: Qty.:

0.1995 f(s)/Unit Total: 3.9900 f(s)

6061_T6 Bar 1.250" x 1.250 (4')

Batch: MO3220

BAND SAW

2.0

3.0

BAND SAW

Comment: BAND SAW

Cut blanks 1.500" long

HAAS CNC VERTICAL MACHINING #1



Comment: 1-Machine as per Folio FA651 and Dwg D3538



MS orlozlos

108

2-Deburr QC2

HAAS1



Comment: INSPECT PARTS AS THEY COME OFF MACHINE



5.0

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK



6.0

HAND FINISHING

HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1



| Dart Ae | rospac | e Ltd | i ș | | | | | | | | |
|--------------|-------------|---|-------------------|-----------------------|--------|------------------------------|----------|----------------------|-------------------------------|------------------------|------------------------|
| W/O: | | | i. | V | VORK | ORDER CHANGES | | | | | |
| DATE STEP PR | | PRO | OCEDURE CHANGE | | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approva QC Inspecto | |
| 30 | | | | | | | | | | | |
| | | | 1 | | | | | | | | |
| | | | | | | | | | | | |
| Part No |): | P | AR #: | Fault Ca | tegory | :N | CR: Yes | No DQA: | Q | Date: _C | 17/02/20 |
| | | | , | | | | QA: N | I/C Closed: | | _ Date: | |
| NCR: | | | W | ORK OR | DER I | NON-CONFORMANC | CE (NCF | ₹) | | | |
| DATE | STEP | Section | A : | Initial Chief Eng) | Corr | Action Description Chief Eng | Sign 8 | Verificat Section | | Approval Chief Eng | Approva QC Inspecto |
| 64/02 | 丑 3.0 | 6 pants scrape Didnit et propri Rémarch: vace 5 Fix. Posblem | Pats y in vise | POSIOUR | Scrap | Peplac | Spection | 6702 | 12 | OD-1212 | 67-12:17 |
| | | | | | | | | | | | |
| | | | 1 | | | < | | | | | |
| NOTE | | al all entries | | | 1.1 | | | | | | |
| NOTE: D | ale a milli | ai ail Cillics | 3 | | | | | | | 144 | |

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

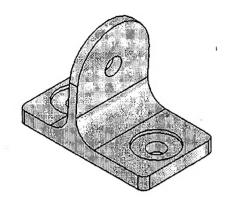
Monday, 2/5/2007 10:45:31 AM Date: Ušer: Kim Johnston **Process Sheet** Drawing Name: HINGE BRACKET Customer: CU-DAR001 Dart Helicopters Services Job Number: 30635 Part Number: D35381 Job Number: Seq. #: Description: Machine Or Operation: POWDER COATING POWDER COATING 7.0 11/10314/ Comment: POWDER COATING Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3 8.0 US Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 9.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 10.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE U 07.02.22 Job Completion

| Dart Ae | rospace | Ltd | | | | | | | 1 | |
|-----------|---------|-------------------|----------|-----------|-----------------------------|----------------|---------|--------------|-------------------------------------|--------------------------|
| W/O: | | | V | VORK C | RDER CHANGES | | | | | |
| DATE STEP | | PROCEDURE CHANGE | | | *_ | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| ٠ | | | | | | | | | i i | |
| | | tronger was | | | | | | | 1 ' | |
| Part No | : | PAR #: | Fault Ca | tegory: _ | N | CR: Yes | | | Date: _ Date: | |
| NCR: | | | WORK OR | DER NO | ON-CONFORMANC | | | | 1 | |
| D.4.TE | 0.750 | Description of NC | <u> </u> | | tive Action Section B | | | Verification | Approval | Approval |
| DATE | STEP | Section A | | | ction Description Chief Eng | Sign 8 Date | Section | | | QC Inspector |
| | | | | 3 | | | | | I L | ÷ |
| | | | | | | | | | i | • |
| | | | | | 4 | | | | 1 | |
| | | 1 | | Í | | į | 1 | | 1 | 7 |

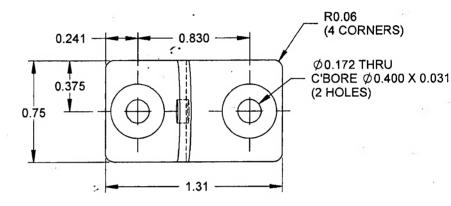
NOTE: Date & initial all entries

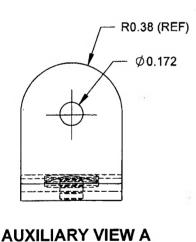


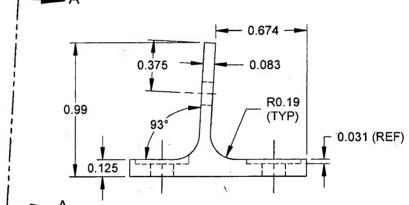
| DESIGN | DRAWN BY | DART AEROSPACE HAWKESBURY, ONTARIO, CA | |
|---------------|----------|---|------------------------|
| CHECKED PH | APPROVED | DRAWING NO. | REV. A SHEET 1 OF 2 |
| DATE | 10.13 | TITLE HINGE BRACKET | SCALE 1:1 |
| REV | DATE | DESCRIPTION | |



06.10.13 NEW ISSUE







D3538-1 HINGE BRACKET

1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B) OLLED COPY
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 006 4.2

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP CORNERS TO 0.010 MAX

6) IDENTIFY WITH P/N D3538-1 USING FINE POINT PERMANENT INK MARKER

SHOP COPY RETURN TO

SUBJECT TO AMENDMENT WITHOUT NOTICE

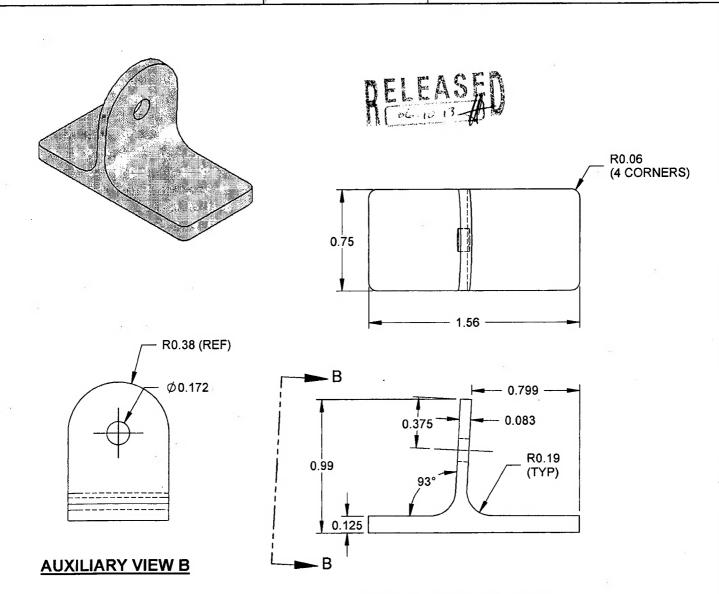
WORK ORDER

COPYRIGHT © 2006 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



| DESIGN | DRAWN BY | DART AEROSPA HAWKESBURY, ONTARIO | |
|-------------|----------------------------|-------------------------------------|------------------------|
| CHECKED PI+ | APPROVED | DRAWING NO. | REV. A SHEET 2 OF 2 |
| DATE 06.1 | └ <i>────//</i> ⁴ 0.13 | TITLE HINGE BRACKET | SCALE 1:1 |



D3538-3 HINGE BRACKET

SHOP COPY RETURN TO ENGINEERING

1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC MGQ6176B) OLLED COPY
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES LINI ESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP CORNERS TO 0.010 MAX

6) IDENTIFY WITH P/N D3538-3 USING FINE POINT PERMANENT INK MARKER

| DART AEROSPACE LTD | Work Order: | 30635 |
|------------------------------|--------------|-------------|
| DART MEROSI NOL LID | | |
| | Part Number: | D3538-1 |
| Description: Hinge Bracket | | |
| V. | | Page 1 of 1 |
| Inspection Dwg: D3538 Rev: A | 1 | 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article 家 Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|----------------------|--------------------|---------------------|---|--------|----------------------|----------|
| .241 | h 0.010 | 241 | | | | |
| ,830 | + 0.010 | .828 | - | | | j. |
| .375 | +0010 | 6.370 | | | | |
| 1.31 | 1.030 | 1.315 | - | | | |
| ٠٦٤ | 10030 | .75 | 111111111111111111111111111111111111111 | | | |
| 99 | 10030 | 0.991 | | | - | |
| .375 | + 0.0(U | .375 | V | 1 | | |
| 930 | | 930 | | | | |
| ٠١٦٢ | + 0.010 | .125 | | · | | |
| °031 | Ref | .033 | <u> </u> | | | |
| R.19 | 10030 | 0.200 | | | lig | , |
| \$E9. | + 0.080 | 0.829 | | | | |
| .674 | 1 - 0.010 | .G10 | | | | |
| R.38 | -0.030 | 0.375 | - | | R-9 | |
| Ø.172 | 4.005 | 6773 | | | | |
| Ø.172 | + C.CIS - E.EGI | 0.175 | | | <u> </u> | |
| | | | | | | |
| 1 | | | | | | |
| | | | | : | | |
| | , | | | | | |
| | | | | | | |

| ······································ | | | | | | |
|--|------|-------|-----------------|-----------|---------------------|----|
| | | 1 | \ | | | |
| Managed by | | 1 | Audited by: | TE. 1 | Prototype Approval: | 1 |
| Measured by: | M8 | (| n conducted by: | <u> </u> | | 94 |
| Data | , / | , EPY | Date: | 07/02/12 | Date: | • |
| Date: | colo | 108 | 2000 | 0// 02/12 | | |

| Rev | Date | Change | Revised by KJ/JLM | Approved |
|-----|------|-----------|----------------------|----------|
| Α | | New Issue | NJ/JLIVI | |

